Date: Tuesday, 7/24/2007 2:11:05 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BRACKET
Job Number	: 33726		
Estimate Number	: 12966		
P.O. Number	:	**Part Number**	: D3637041
This Issue	: 7/24/2007 **S.O. No.** :	**Drawing Number**	: D3637 UNDER REVIEW
Prsht Rev.	: NC	**Project Number**	: AC0005
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: U/R
Previous Run	:	**Material**	:
Written By	: JLM 07-07-24	**Due Date**	: 7/31/2007 **Qty:** 2 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 07-07-20 JLM	**Verified By:**	

Additional Product

PROTOTYPE

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080

Comment: Qty.: 0.0945 sf(s)/Unit Total : 0.1890 sf(s)
304SS .080
Batch: M10S 112 LB 07-07-30

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3637
Dwg Rev: PROTO
Prog Rev: TYPE LB 07-07-30

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

LB 07-07-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

LB 07-07-30

Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
Form as per Dwg D3637

LB 070803

Date: Tuesday, 7/24/2007 2:11:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BRACKET

Job Number: 33726 **Part Number:** D3637041

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	MS21059L4	Nutplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nutplate
BATCH: M102959

7.0	MS20426AD33	Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Rivet
BATCH: M1503

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'Sink as per Dwg D3637

2-Install Nut plate as per Dwg D3637 07.08.03

9.0	QC5	INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL UE 07.08.08.

Comment: INSPECT WORK TO CURRENT STEP

10.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: N/A

11.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/08/08

Job Completion FOR ENGINEERING USE ONLY w/000104 V

U 07.08.08

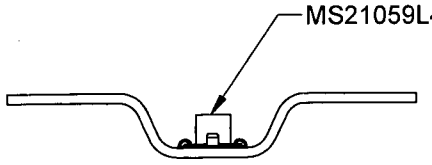
ENGINEERING APPROVAL UE 07-0808

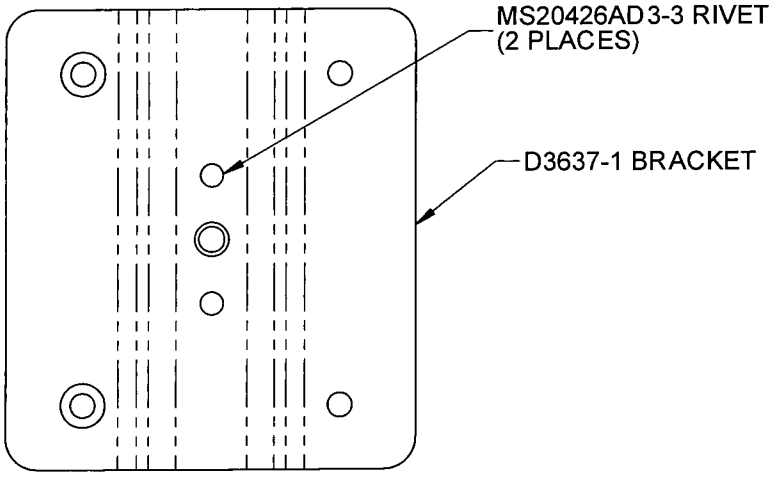
Form: rprocess

DESIGN	DRAWN BY	DART AEROSPACE LTD
TS	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3637 REV. A
QP		SHEET 1 OF 3
DATE 07.07.24		TITLE BRACKET SCALE 2:3

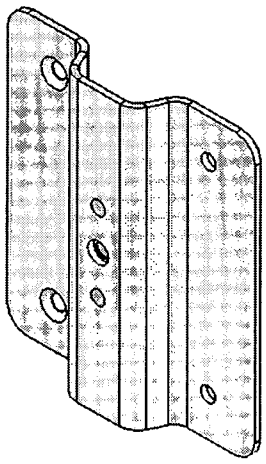
REV	DATE	DESCRIPTION
A	07.07.24	NEW ISSUE; REPLACES G10608, G10602 & G10609

PROTOTYPE
PLEASE RETURN ALL ISSUED DATA TO ENGINEERING
LE 07-07-24





D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)



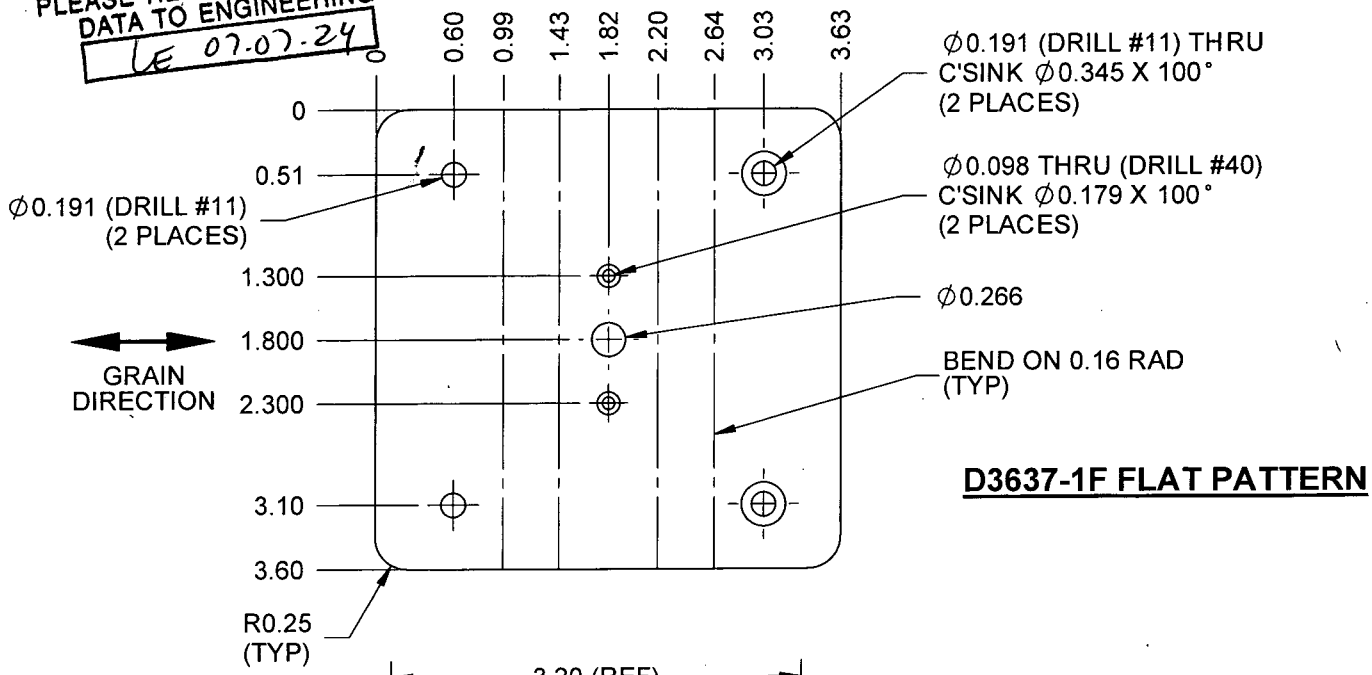
D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	M21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

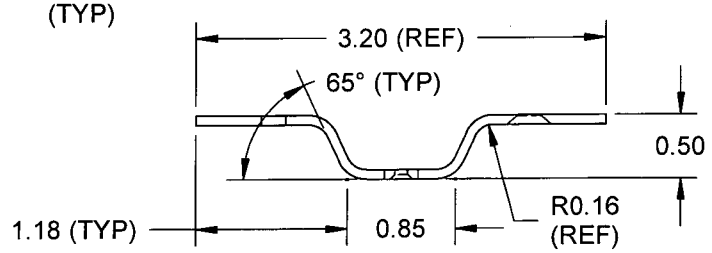
D3637-041 NOTES:
1) IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER

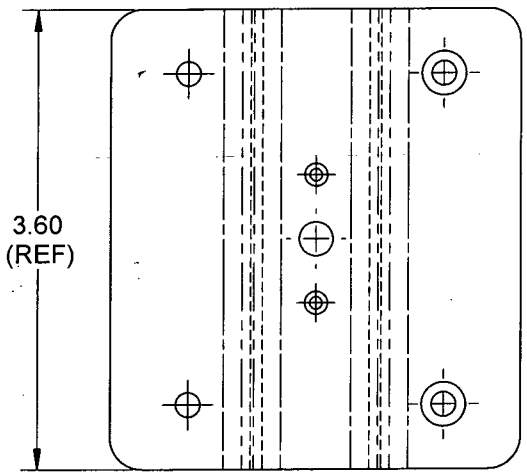
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
TS	LE		
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3637	SHEET 2 OF 3
DATE		TITLE	SCALE
07.07.24		BRACKET	2:3

PROTOTYPE
PLEASE RETURN ALL ISSUED DATA TO ENGINEERING
LE 07-07-24

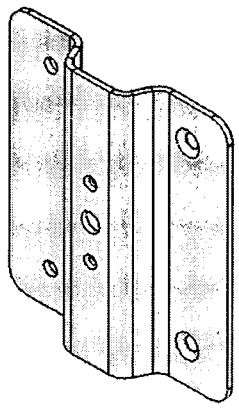


D3637-1F FLAT PATTERN





D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



D3637-1 NOTES:
1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5019 (REF DART SPEC M304S14GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

DART AEROSPACE LTD	Work Order:	33726
Description: BRACKET	Part Number:	D3637-041
Inspection Dwg: Rev: PROTOTYPE		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.51	+/- .030	.51	X			
1.300	+/- .030	1.300	X			
1.800	+/- .010	1.800	X			
2.300	+/- .010	2.300	X			
3.10	+/- .030	3.10	X			
3.60	+/- .030	3.60	X			
.60	+/- .030	.60	X			
1.82	+/- .030	1.82	X			
3.03	+/- .030	3.03	X			
Ø .098	+.004 -.001	.101	X			
Ø .191	+.004 -.001	.191	X			
Ø .366	+.006 -.001	.366	X			
.363	+/- .010	.364	X			

Measured by:	MB	Audited by:		Prototype Approval:	LE
Date:	07-07-30	Date:		Date:	07.08.08

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	